

Date: Thursday, 19/02/2009 10:06:41 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACERS (1/4 THICK)
Job Number : 45885	
Estimate Number : 10247	
P.O. Number :	Part Number : D2022101
This Issue : 19/02/2009 S.O. No. :	Drawing Number : D2022 REV. -
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : -
Previous Run : 41928	Material :
Written By :	Due Date : 26/02/2009 Qty: 500 Um: Each
Checked & Approved By : <u>JUD 09.02.09</u>	
Comment : Est D 02.03.07 Now made in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total : 16.4325 f(s) + .75 = 17.1325
6061T6 Round Bar .750"

Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
(M6061T6RO.750 Batch: M110791

09/02/23

500 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1- Note: .257(F) Dia drill
2-Turn Blank as per FolioFA206
3-Tumble & deburr any sharp edges as per dwg

09/02/23

500 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/02/23

500 pcs

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

09/02/23

500

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 5

9/2/24

500X

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACERS (1/4 THICK)

Job Number: 45885

Part Number: D2022101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-24

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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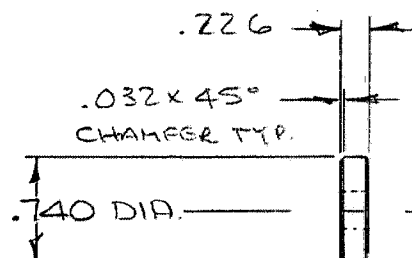
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
970114 BW



D2022-101
D2022-103

DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

MAT'L : ALUMINUM 6061-T6 (QQ-A-225/B)



D2022-103	SPACER 5/16	ALUM. 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/B

REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		QTY. REQUIRED		APPROVAL		CONTRACT NO.		DART AERO ACCESSORIES INC	
DRAWN				BASIC CODE		DIA. DASH NO. IN HEAD NEAR SIDE F-HEAD FAR SIDE				DRAWN BRADLEY		DATE 9/10/65	
APPROVED				D-DIMPLE D-DIMPLE OF SHEET C-COUNTERDRILL		LENGTH DASH NO. IN-SPOTWELLED				DESIGN BRADLEY		CLIENT	
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES						STRESS		TITLE SPACERS	
		GENERAL		BASIC CODES						CHECKED		CODE	
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMAIN. SHARP EDGES 0.125 MAX 4. THREADS PER IN. - 2 - 7/16 5. HOLES PER IN. 10/32		1. TOLERANCES - .001 & .002 2. ANGLES - 45° & 90° 3. PARALLELISM - .0025 4. COPLANARITY - .0025 MAX 5. SYMMETRY ABOUT ALL MTC CENTRE LINES .002		BASIC CODES						DIAL. NO. D2022	
		REPORT ALL DISCREPANCIES - DO NOT SCALE								CLIENT		SCALE 1:1	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1588

D2022

W/O:		WORK ORDER CHANGES					
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